

Work Order ID 63997 -2

Tuesday, November 23, 2010 9:25:54 AM

SPLIT



Page 1

Item ID: D3537-1

Accept

Revision ID:

Item Name: Wearpad

Start Date: 11/22/2010 Start Qty: 50.00

Required Date: 11/30/2010 Req'd Qty: 50.00

Reference:



Setup Start

Stop

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date: 10-11-23 Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3537

Rev C

100



Waterjet

FLOW CNC Waterjet

304.062

FLOW WATER JET

0.00

Memo

0.00

1-Cut as per Dwg D3537 Dwg Rev: C Prog Rev: C 2-Deburr if necessary

B10-11-24

56

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

B10-11-24

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

8/10/124

counted
X56

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Page 2

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Start Date: 11/22/2010 Start Qty: 50.00

Required Date: 11/30/2010 Req'd Qty: 50.00

Reference:

Accept

Cust Item ID:
Customer:

Setup Start

Stop

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

0.00

Memo

0.00

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D3537-1

SG

SB 10/11/29

140



Large Fab

Large Fab

Large Fab

0.00

Memo

0.00

Qty Description Batch A/R 2059B Hardcoat
1116288 1-Weld as per Dwg D3537 using Jig DT 8210 2-Remove any weld that penetrated through Wearpad if necessary

EL 10-12-8

X33
X40

150



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

SB 10/12/08

can't

X33

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Accept



Setup Start



Stop



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Required Date: 11/30/2010 Req'd Qty: 50.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/10/10/09

count
733

170



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per OSI005 4.3

0.00

Memo

0.00

START TIME:

3:45

OVEN TEMPERATURE:

FINISH TIME:

4:15

33 10-12-8

180



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

=> 10/12/09

33 0

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Accept



Setup Start



Stop



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Required Date: 11/30/2010 Req'd Qty: 50.00

Reference:



Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Tooling:

Date:

Run Start



Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

190



Packaging

Packaging

Operation
Description

Identify as per dwg & Stock Location:

FR-17

Set Up/
Run Hours

0.00

Memo

0.00

Tool ID Tool # Plan
Code

Accept Reject Reject Insp.
Qty Qty Number Stamp

33 10-12-9

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/12/09

10-12-9
33

Picklist Print

Tuesday, November 23, 2010 9:25:58 AM

Page 1

Work Order ID: 63997

Parent Item: D3537-1

Parent Item Name: Wearpad



Start Date: 11/22/2010

Required Date: 11/30/2010

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	140.6000	0.106	5.578947	6		

M304S16GA



304/316 Sheet.063



113 10-11-24

Location

MAT

Loc Qty

140.6

111323

0

115688

3.6

115953

137

Loc Code

115953

(56)

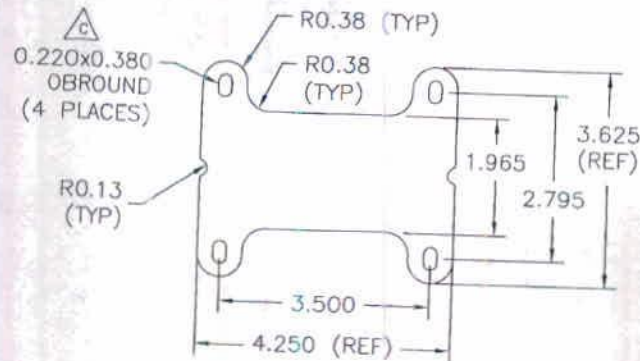
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

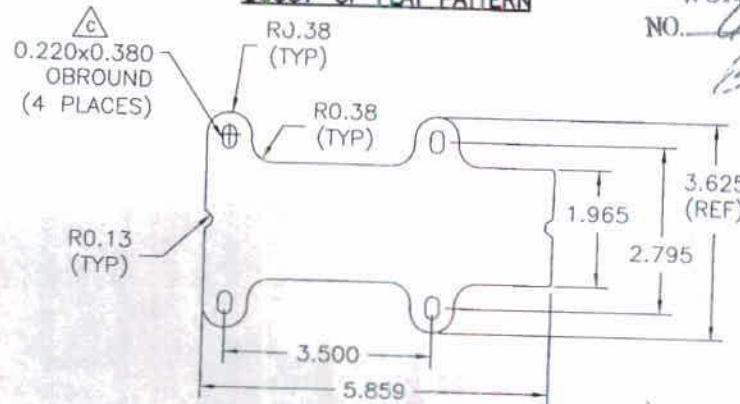
NO. 63997

3/10/11-23

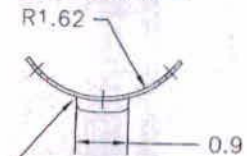
D3537-1F FLAT PATTERN



D3537-3F FLAT PATTERN

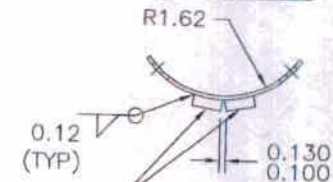


SECTION A-A



APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

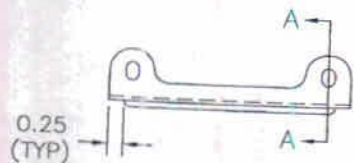
SECTION B-B



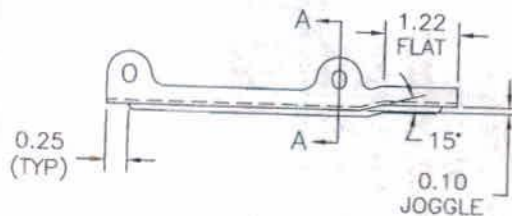
D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

RELEASED
07.05.08 AH
per EUN

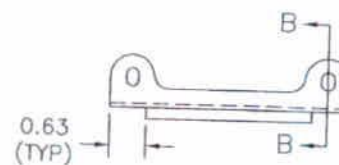
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



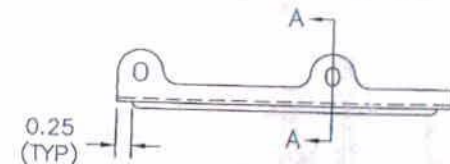
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY AH
CHECKED	4	APPROVED 4
DATE	07.04.13	DRAWING NO. D3537
		TITLE WEARPAD
		DART AEROSPACE USA, INC. PORT HADLOCK, MA
		REV. C
		SHEET 1 OF 1
		SCALE
		1/2